

15/03

DART AEROSPACE LTD	Work Order:	22064
Description: Wearplate	Part Number:	D2577-5
Dwg: D2577 Rev. E	Qty:	50
		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveller Dwg not required	PH	04.12.08	50
2	PG	Issue P/O: 2007269 Email or Ship DXF file to vendor Laser Cut per Dwg D2577 flat pattern D2577-5 Material release note required	UL	04.12.09	50
3	RG	Receive and Inspect for transit damage Ensure that material release note is attached	CD	05/01/11	50
4	QC6	Inspect dimensions per template D2577-5T1	2	05.02.02	50
5	GB	Deburr if necessary	N/A 2		
6	GB	Form on brake using DT8155 and DT8179 as per Dwg D2577	2	05.02.02	50
7	GB	Form joggle using DT8157 as per Dwg D2577 Identify as D2577-5	2	05.02.02	50
8	QC5	Inspect work to Step 7	ML	05/02/14	50
9	FP	Powder Coat Grey (Ref.4.3.5.6) per QSI 005 4.3	ML	05.02.15	50
10	QC3	Inspect Powder Coat	C2	05/02/15	50
11	FP	Identify and Stock	ML	05.02.15	50
12	AC	Cost / part 16.08	S4C	05.02.16	50
13	DC	Close W/O 16.35 Inspect Level 21	PH	05.02.16	50

Rev	Date	Change	Revised By	Approved
A	96.08.20	New Issue		
B	98.04.15	Changed finish detail, changed forming sub-contractor	KB	
C	99.02.02	Added inspection levels, Jig numbers	DM	
D	99.03.25	Added Joggle	DM	
E	00.10.02	Rev.E dwg	EC	
F	02.09.24	Re-format	KJ RF	RF

RELEASED
02/10/02 RF

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Dec 06, 2004
11:09 am

Work Order No	: 0022064	Department Code:	
Project Name	: D2577-5	Burden Flags	: NNNNNNNN
Project For	: WK503	WO Status	: Open
Work Order Type	: Main	Invoice State	: Not Invoiced
Main WO Number	:	Invoice Date	:
House Part Number	: D2577-5	Invoice Number	:
Description	: Wearplate, Centre	Invoice Amount	: 0.00
Manufactured	: Yes		
Amount Req'd	: 50	Order Entry No	:
Amount Done	: 0	OE Value	: 0.00
Start Date	: 12-06-04		
Est Finish Date	: 01-15-05	Est Margin	: 0.000%
Act Finish Date	:	Actual Margin	: 0.000%
Drawings Req'd	: No		
Ok for Approval	:		
Approval Rec'd	:		

\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	: 0.00	0.00	0.00	0.00	0.00
Engineering Hours	: 0.00	0.00	0.00		
Engineering Cost	: 0.00	0.00	0.00	0.00	0.00
Production Hours	: 0.00	0.00	0.00		
Production Cost	: 0.00	0.00	0.00	0.00	0.00
Packaging Hours	: 0.00	0.00	0.00		
Packaging Cost	: 0.00	0.00	0.00	0.00	0.00
OverHead Hours	: 0.00	0.00	0.00		
OverHead Cost	: 0.00	0.00	0.00	0.00	0.00
CNC Hours	: 0.00	0.00	0.00		
CNC	: 0.00	0.00	0.00	0.00	0.00
Misc. Hours	: 0.00	0.00	0.00		
Misc.	: 0.00	0.00	0.00	0.00	0.00
Burden	: 0.00	0.00	0.00		
Total Cost	: 0.00	0.00	0.00		
Margin	: 0.000	0.000			
Selling Cost	: 0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	: 0.00	0.00
Profits/(Loss)	: 0.00	0.00



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(06) 2358 080 Waiuku
Fax: (09) 3755 959 Telex: 28836

TEST CERTIFICATE

Ref: 3228/1122

CUSTOMER	Wilkinson	P3010901001	SPECIFICATION	ASTMA1008 CS Type A	CERTIFICATE No	TC065404
CUSTOMER Q/N	90-Z1N-525		PRODUCT	CRA TINE COIL	PAGE	1 of 1
MILL Q/N	357274		DIMENSIONS	0.055" x 48" x Coil	DATE	08 April 2003

PACK NUMBER	CHEMICAL COMPOSITION PERCENT																	MECHANICAL TESTS (TEST SPECIFICATION - ASTM A370)					
	HEAT No	C	Si	Mn	P	S	Cu	Ni	Cr	Mo	V	Nb	Ti	Al	B	N	CE	BEND 180°	YIELD	T.S.	%ELONG	HARDNESS	LENGTH (feet)
		x100	x1000	x10000	x100	G.L. =	HRB	()															
R9-404632-00	622644	4	TR	17	12	16												Good				47	1539
R9-404633-00	622644	4	TR	17	12	16												Good				47	1512
R9-404634-00	622652	4	TR	20	12	14												Good				50	1588
R9-404635-00	622652	4	TR	20	12	14												Good				50	1568
R9-404636-00	622652	4	TR	20	12	14												Good				48	1506
R9-404637-00	622652	4	TR	20	12	14												Good				48	1499

YIELD	GAUGE LENGTH (G.L.)	PLASTIC STRAIN RATIO (i)	IMPACT TEST	CARBON EQUIVALENT VALUE (CE)
(A)=0.2% PROOF STRESS	(A)=200mm (C)=80mm (E)=2"	(A)=0 (C)=45	(C)=5mm x 5mm (A)=10mm x 10mm (D)=2.5mm x 10mm (E)=5mm x 10mm	(A)=C+Mn/6 (B)=C+Mn/6+(Cr+V+Mo)/5+(Cu+N)/15
(B)=LOWER YIELD STRESS	(B)=50mm (D)=6.95 (F)=8"	(B)=90 (D)=10+(8D+2.45)/4		(C)=C+Mn/6+Si/24 (D)=

WE HEREBY CERTIFY THAT THE MATERIAL DESCRIBED HEREIN HAS BEEN TESTED AND INSPECTED WITH SATISFACTORY RESULTS IN ACCORDANCE WITH THE REQUIREMENTS OF THE ABOVE SPECIFICATION

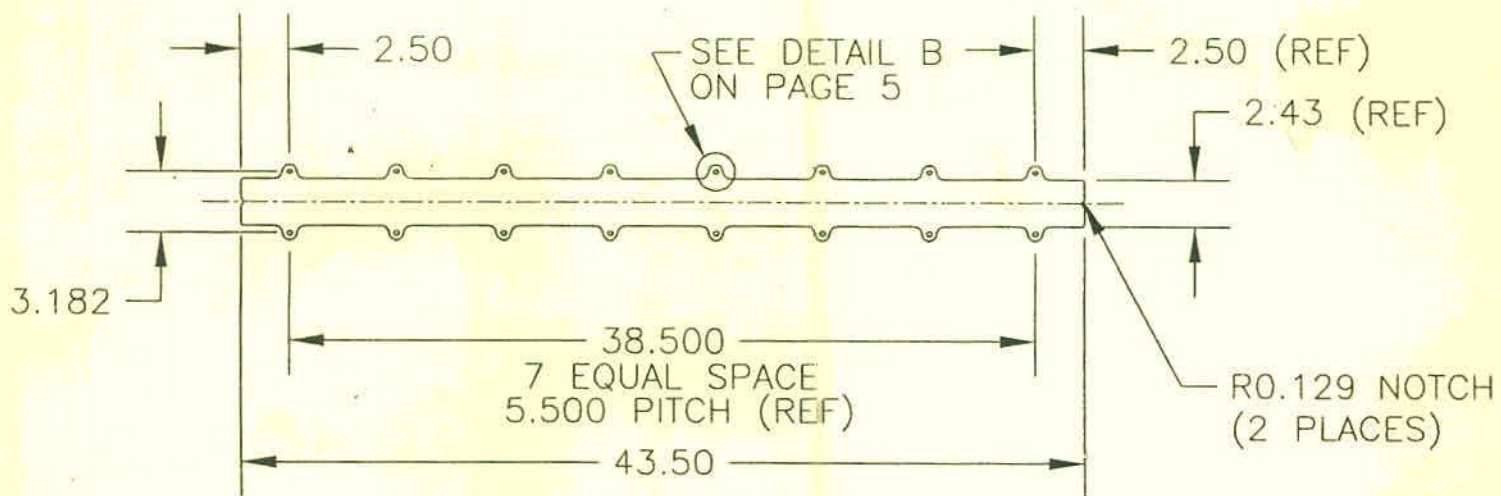
APPROVED *Satish Misra*
QC METALLURGIST

16 ga crms

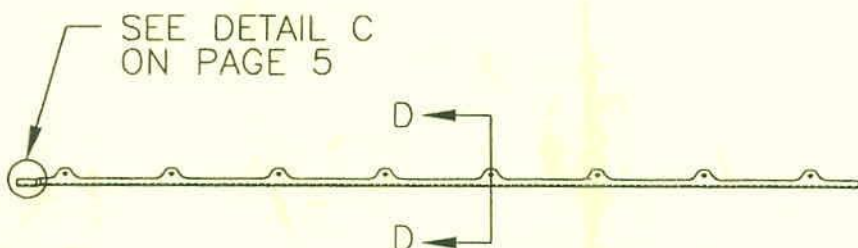


DESIGN	<i>[Signature]</i>	DRAWN BY	<i>[Signature]</i>	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO. D2577
DATE	00.09.22	TITLE	WEARSHOE	REV. E SHEET 3 OF 5
		SCALE	1:10	

D2577-5 FLAT PATTERN



D2577-5 LONGITUDINAL BEND



REFERENCE ONLY

D2577-5 WEARSHOE

BREAK ALL SHARP CORNERS 0.010 TO 0.020

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570

SERIES STEEL 0.063 THICK

FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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00.07.26

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